

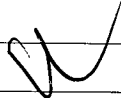
Work Order ID 131291

131291

April-02-15 10:29:04 AM

Page 1

Item ID: D4018-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Short Basket Lid Assembly (350)
 Start Date: 4/02/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/17/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan:  Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4018	D
D4020	A

100 Weld per dwg A/R S.S. rod Batch: 131417 0.00

100

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D4018 using DT9607B

2- weld hinge (3) and Mounting brackets as per dwg D4018
 inspect before welding mesh

3- Cut mesh as per dwg D4020-7

4- tack weld mesh on basket as per dwg D4018
 ***make sure to place mesh correctly on lid, check with label plate before
 tacking mesh***

MAY 12 2015

DAS
24
9-89

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

① 15-05-12

DAS
9
9-89

131291

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/02/15 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 4/17/15 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NB2***

[illegible]

130 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00
130
 Powdercoat
 Powder Coating
 Memo
 *** mask sides of hinge prior to powdercoat ***
 Start Time: 2:00
 Oven Temperature: 320°
 Finish Time: 2:30

140	Wing Walk as per dwg OSI005 4.4 Batch <u>1413203</u>	0.00
140		
HandFinish	Memo	0.00
Hand Finishing	1- Mask data plate and apply wing walk on outside	

Install placard and label as per dwg
 ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area
 for label, apply label ***

Page 3

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Reference:

Stop ***NR2***

MAY 19 2015

Packaging

Quality Control

MLJ MAY 20 2015

ME
15-5-10

Picklist Print

April-02-15 10:29:03 AM

Page 1

Work Order ID: 131291

131291

Parent Item: D4018-041

D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 4/02/15

Required Date: 4/17/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg
RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD
10.08.18 verified by:EC IPP REV:E 13.08.21 DWG REV.D / ECN 13-
624 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304EX0.75-16F

Purchased

No

100

sf

1,048.861

8.4578

9

M304FX0 75-16F

Expanded Metal Flat SS

DL 15/5/25

Location

Loc Qty

Loc Code

WA004

480

M131848

480

WA006

568.8612

M131107

129.8612

M131629

439

D4018-1

Manufactured

No

100

Each

2.0000

2

2

D4018-1

Rib

24 DAS

MAY 12 2015

Location

Loc Qty

Loc Code

WA004

2

120354

2

D4018-3

Manufactured

No

100

Each

6.0000

2

2

D4018-3

Rib

DL 15/5/25

Location

Loc Qty

Loc Code

WA004

6

121814

6

6

Picklist Print

April-02-15 10:29:03 AM

Page 2

Work Order ID: 131291

131291

Parent Item: D4018-041

D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 4/02/15

Required Date: 4/17/15

Start Qty: 1.00

Required Qty: 1.00

D4016-3 Manufactured No

100 Each 13.0000 3 3

D4016-3

Hinge Half, Lid

DAS
24
9-89

MAY 12 2015

Location

Loc Qty

Loc Code

WA004

13

130006

13

D4018-5 Manufactured No

100 Each 39.0000 6 6

D4018-5

Rib

DAS
24
9-89

MAY 12 2015

Location

Loc Qty

Loc Code

WA004

39

117453

39

D4035-043 Manufactured No

100 Each 10.0000 2 2

D4035-043

Lid Rib Assembly, Aft (350 Basket)

DAS
24
9-89

MAY 12 2015

Location

Loc Qty

Loc Code

WA004

10

127809

2

129769

8

D2581 Manufactured No

100 Each 83.0000 2 2

D2581

Mounting Bracket

DAS
24
9-89

MAY 12 2015

Location

Loc Qty

Loc Code

WA004

83

102265

38

127716

45

Picklist Print

April-02-15 10:29:04 AM

Page 3

Work Order ID: 131291

131291

Parent Item: D4018-041

D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 4/02/15

Required Date: 4/17/15

Start Qty: 1.00

Required Qty: 1.00

D4021-3

Manufactured No

100

Each

2.0000

1

1

D4021-3

Data Plate

DAS

24

9-89

MAY 12 2015

Location

Loc Qty

Loc Code

WA004

2

125833

2

D2728-3

Manufactured Yes

140

Each

0.0000

0

0

D2728-3

Dart Logo Label Large

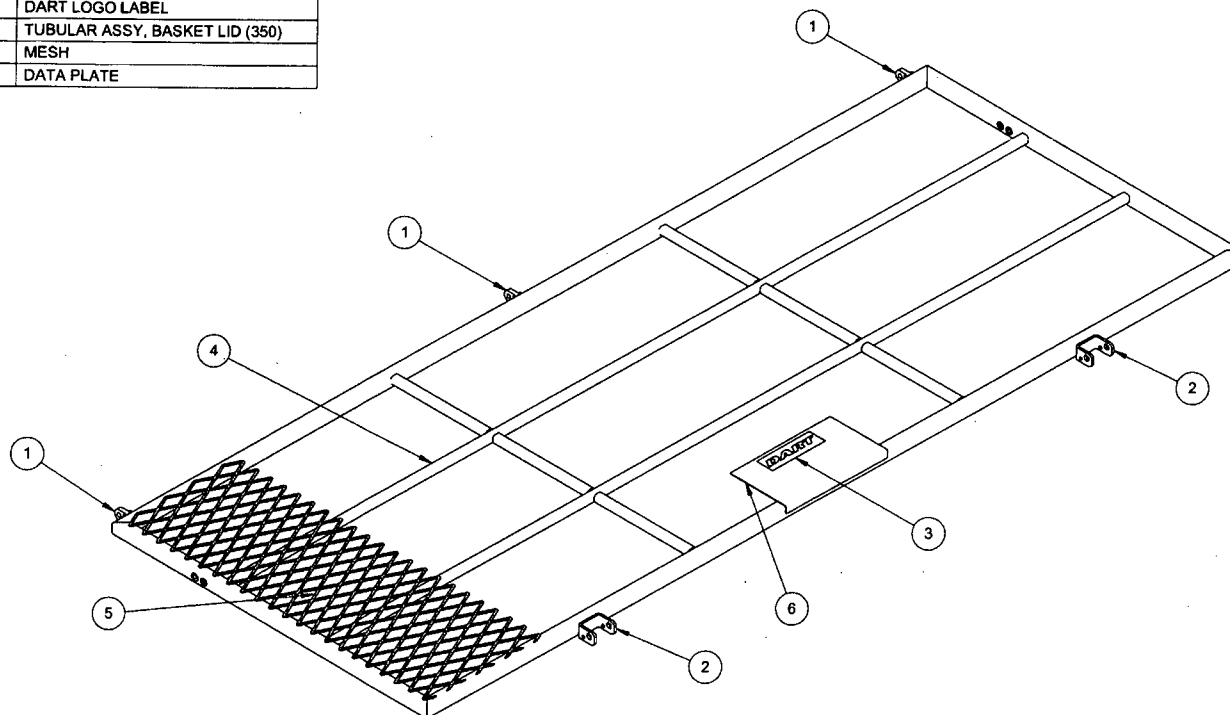
B 130004 -> 1

April-02-15 10:29:04 AM

Shop Packet Print

Page 3

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE

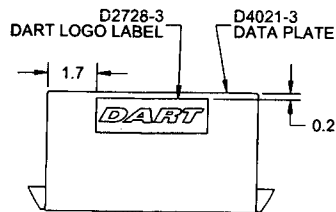
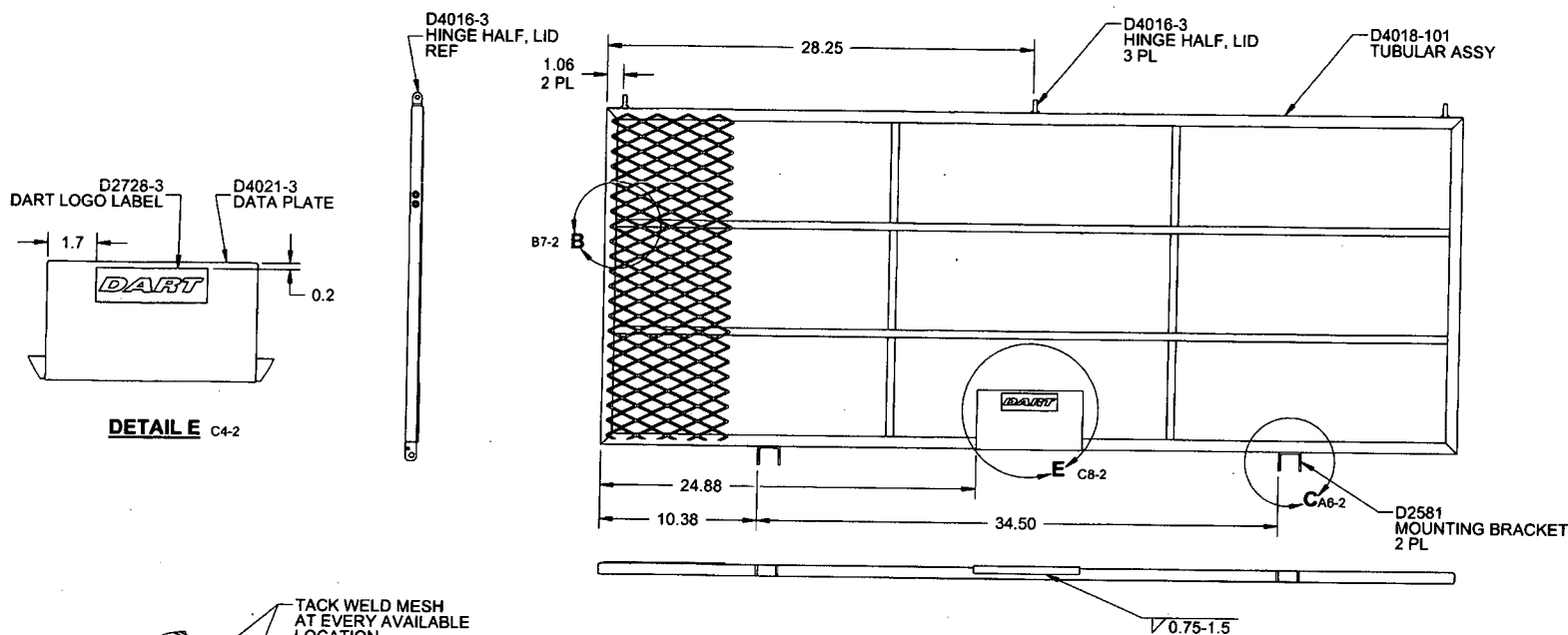


D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

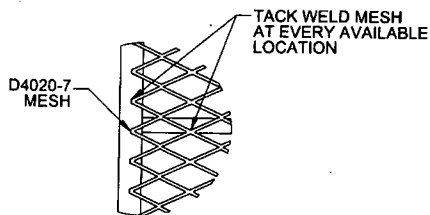
alb
13/29/1

RELEASED
2013-08-16

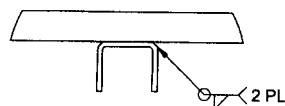
D	C7-3 D4035-043 WAS D4035-041 (REASON: PROPARM OPTION DELETED).	AJS	13.07.18
C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-807-2 REV. C AND D350-807-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	47	DRAWING NO.	REV. D
MFG. APPR.	194	D4018	SHEET 1 OF 4
APPROVED	194	TITLE	SCALE
DE APPR.		SHORT BASKET LID ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



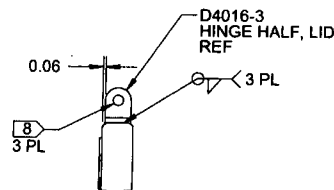
DETAIL E C4-2



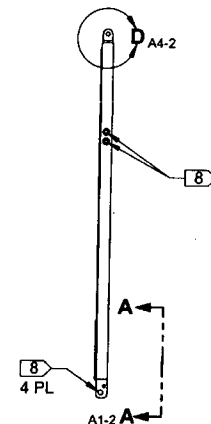
DETAIL B C6-2



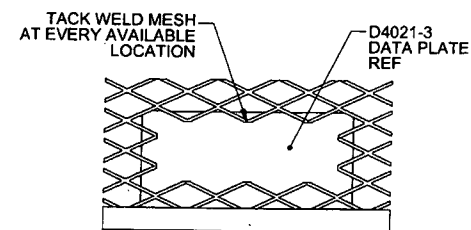
DETAIL C C3-2



DETAIL D D1-2



VIEW A-A C1-2

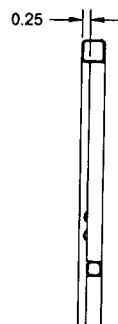


- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.5 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

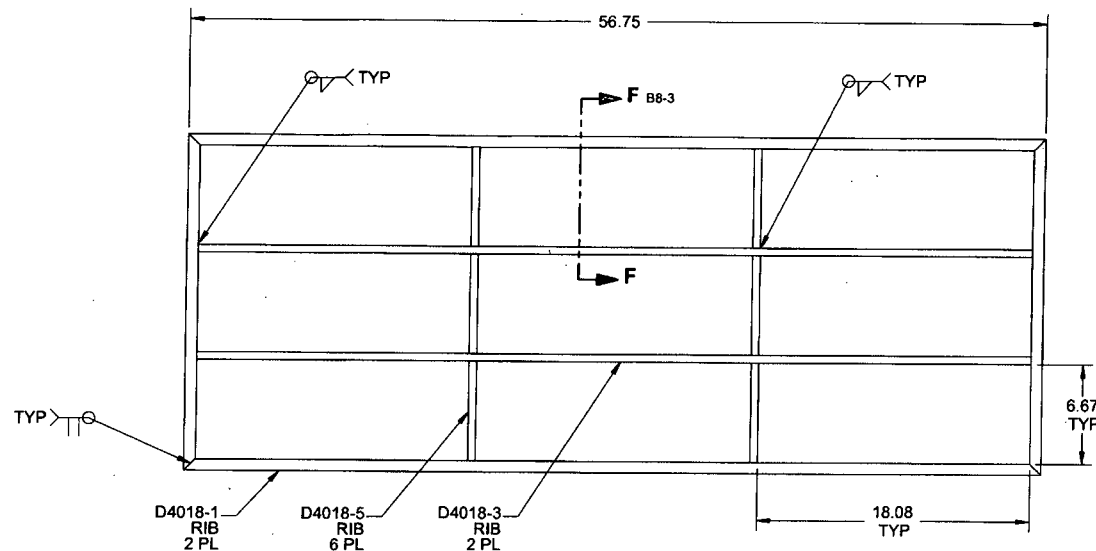
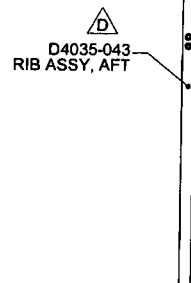
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4018	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET LID ASSY (350) NTS	
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
2013-08-16

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



SECTION F-F C3-3

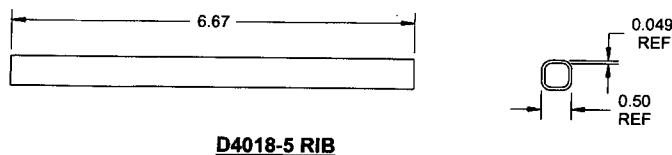
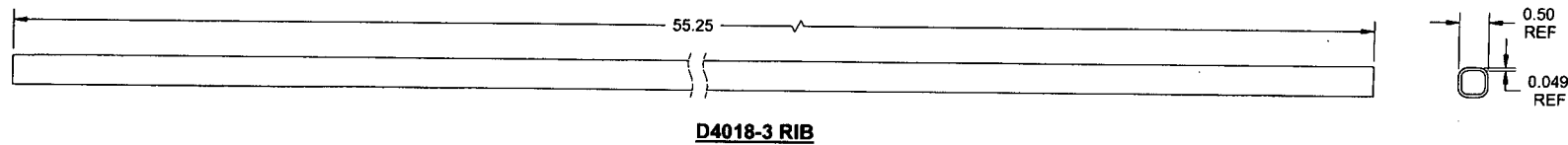
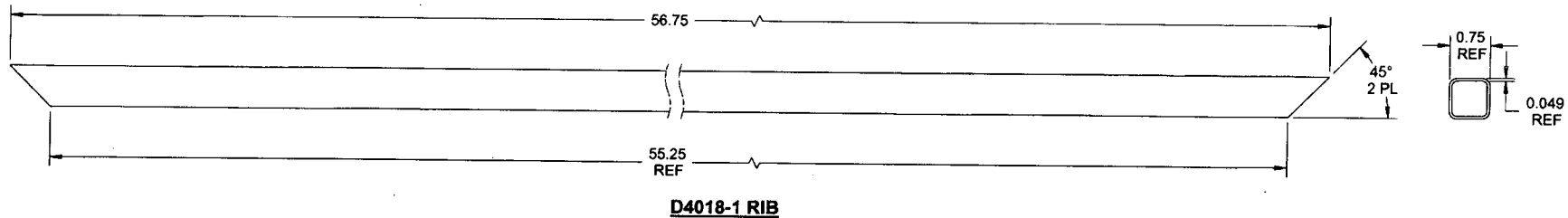


8 D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED
2013-08-16

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.06 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4018	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET LID ASSY (350)	NTS
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NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
2013-08-16
MHP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LP	DRAWING NO.	REV. D
MFG. APPR.		D4018	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET LID ASSY (350)	NTS
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